

*Split***Work Order ID 54326-2**

December 8, 2009 8:33:16 AM



Page 1

Item ID: D3782-043

Accept



Setup



Start



Revision ID:

Item Name: Front Outboard Leg Assembly, LH

Start Date: 08/12/2009 Start Qty: 10.00



Cust. Item ID:

Required Date: 16/12/2009 Req'd Qty: 10.00

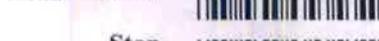


Customer:

Reference:

Approvals: Process Plan: *PL*Date: *09/12/09* Tooling: _____ Date: _____

Run



Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3782	Rev A

100 Pick Kit 0.00



Packaging

Memo

0.00

Packaging

EP 10/01/13 ⑦

110 Small Fab 0.00



Small Fab

Memo

0.00

Small Fab 1-assemble as per dwg D3782

EP 10/01/13 ⑦

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

*88 10/01/14**7 8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54326

December 8, 2009 8:33:16 AM



Page 2

Item ID: D3782-043

Accept



Setup



Start



Revision ID:

Item Name: Front Outboard Leg Assembly, LH

Stop



Start Date: 08/12/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Identify as per dwg & Stock Location: <u>249A</u>	0.00							
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Packaging

Packaging

10-1-14



140	QC21- Final Inspection - Work Order Release	0.00							
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QC

Quality Control

Memo

0.00

10/01/15

MF 10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 8:33:20 AM

Page 1

Work Order ID: 54326



Parent Item: D3782-043



Parent Item Name: Front Outboard Leg Assembly, LH

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN45-13A



Purchased

No

110

Each

31.0000

20.0000



EYE BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST	31	
109712	4	
111975	27	

AN960JD516



Purchased

No

110

Each

976.0000

20.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST	976	
110363	46	
110523	57	
111279	39	
112082	64	
112314	14	
112828	256	
113149	500	

D3762-041



Manufactured

No

110

Each

0.0000

10.0000



Front Leg Fitting Assembly

BB10/01/13
M113509 (14x)

BB10/01/13
M112794 (13x)

M113237 (1x)

BB10/01/13
B54335 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 8:33:20 AM

Page 2

Work Order ID: 54326



Parent Item: D3782-043



Parent Item Name: Front Outboard Leg Assembly, LH

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3768-3		Manufactured	No		110		Each	4.0000	10.0000		<i>EP 10/01/13</i>	
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Front Outboard Leg, LH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

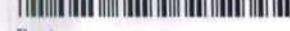
ST

4

42239

4

D3787-1		Manufactured	No		110		Each	36.0000	10.0000		<i>EP 10/01/13</i>	
---------	--	--------------	----	--	-----	--	------	---------	---------	--	--------------------	--



Foot

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

36

39397

3

46597

33

MS21042L5		Purchased	No		110		Each	730.0000	20.0000		<i>EP 10/01/13</i>	
-----------	--	-----------	----	--	-----	--	------	----------	---------	--	--------------------	--



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

730

110382

10

111636

11

112314

709

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

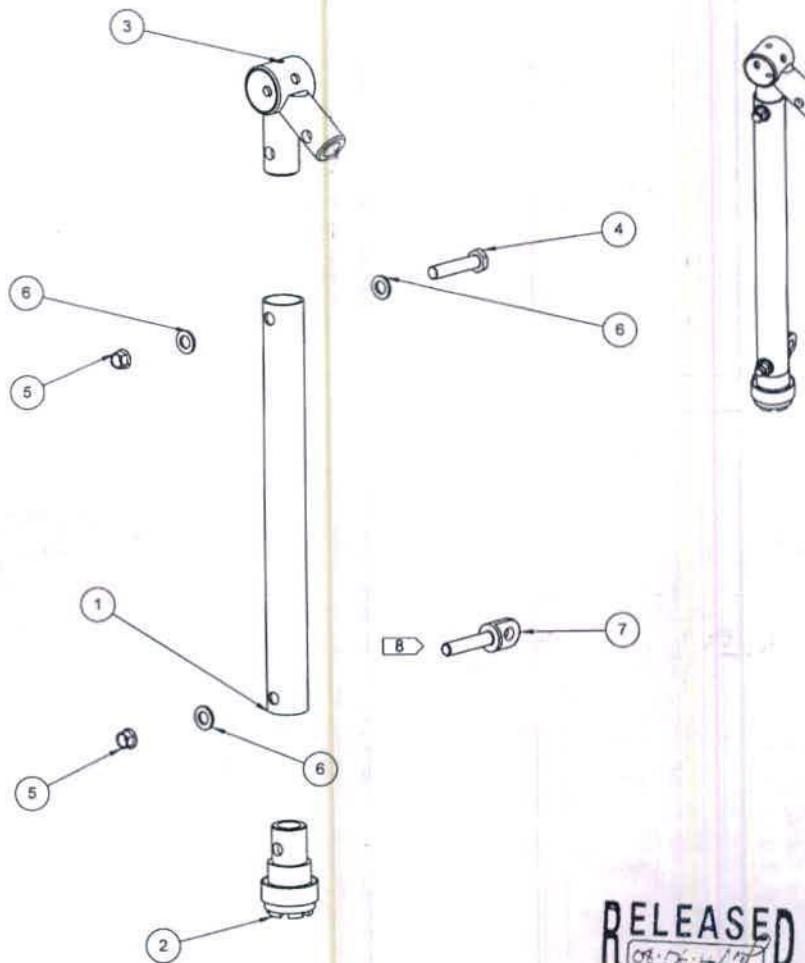
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3768-1	FRONT INBOARD LEG	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN5-13A	BOLT	1
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	3
7	AN45-13A	EYE BOLT	1

SHOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 54324
PL 092-8



RELEASED
08-06-11-17

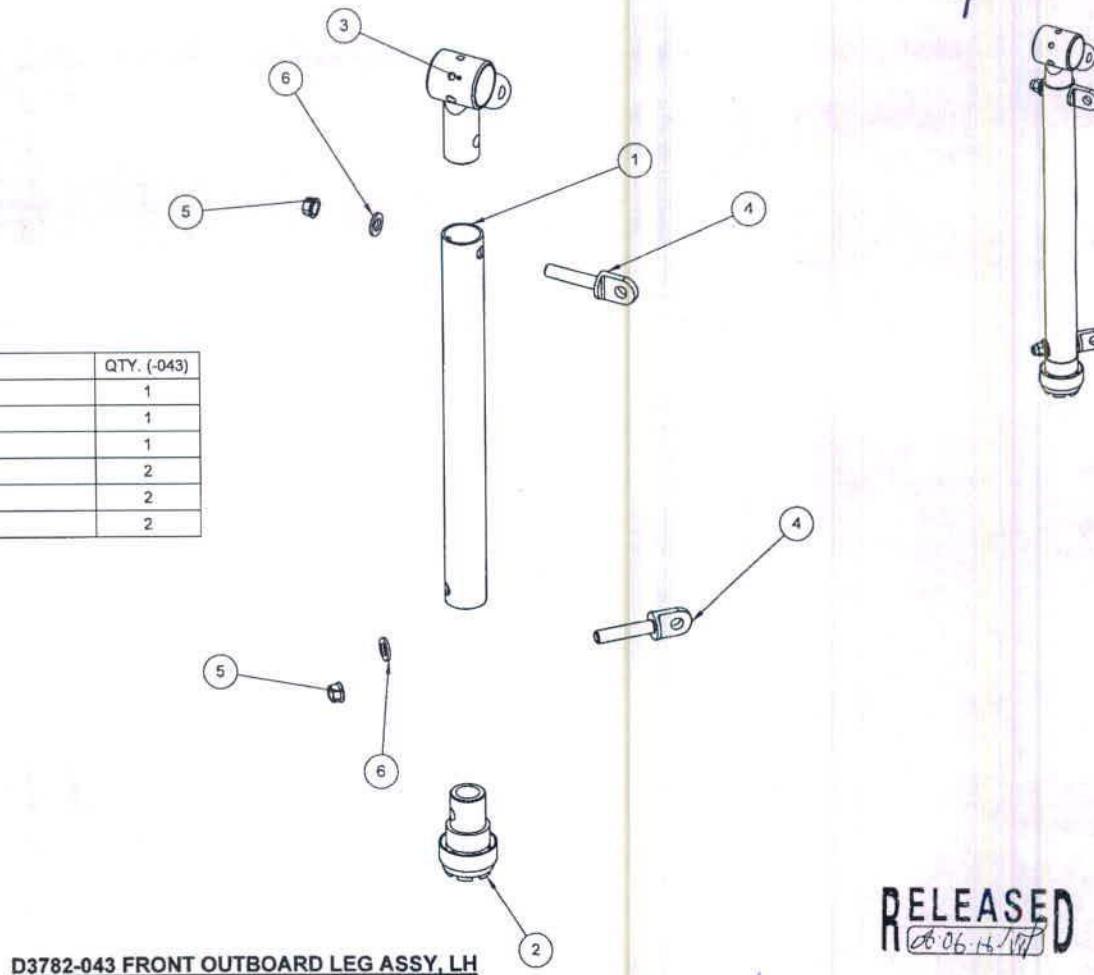
D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs
 8) ITEM 6 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
 INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. A	
MFG. APPR.		D3782	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	NTS
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3768-3	FRONT OUTBOARD LEG, LH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN980JD516)	2



RELEASED
08.06.16/107

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3782	
MFG. APPR.		REV. A	
APPROVED		SHEET 2 OF 4	
DE APPR.		TITLE	
DATE	08.06.04	SCALE NTS	
LEG ASSEMBLY			

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NOTES:
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 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3768-4	FRONT OUTBOARD LEG, RH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2



D3782-044 FRONT OUTBOARD LEG ASSY, RH

RELEASED
08-06-14/14

W0 54326

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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		REV. A
APPROVED		D3782 SHEET 3 OF 4
DE APPR.		TITLE
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		NTS
		LEG ASSEMBLY
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

8

7

6

5

4

3

2

1

A

D

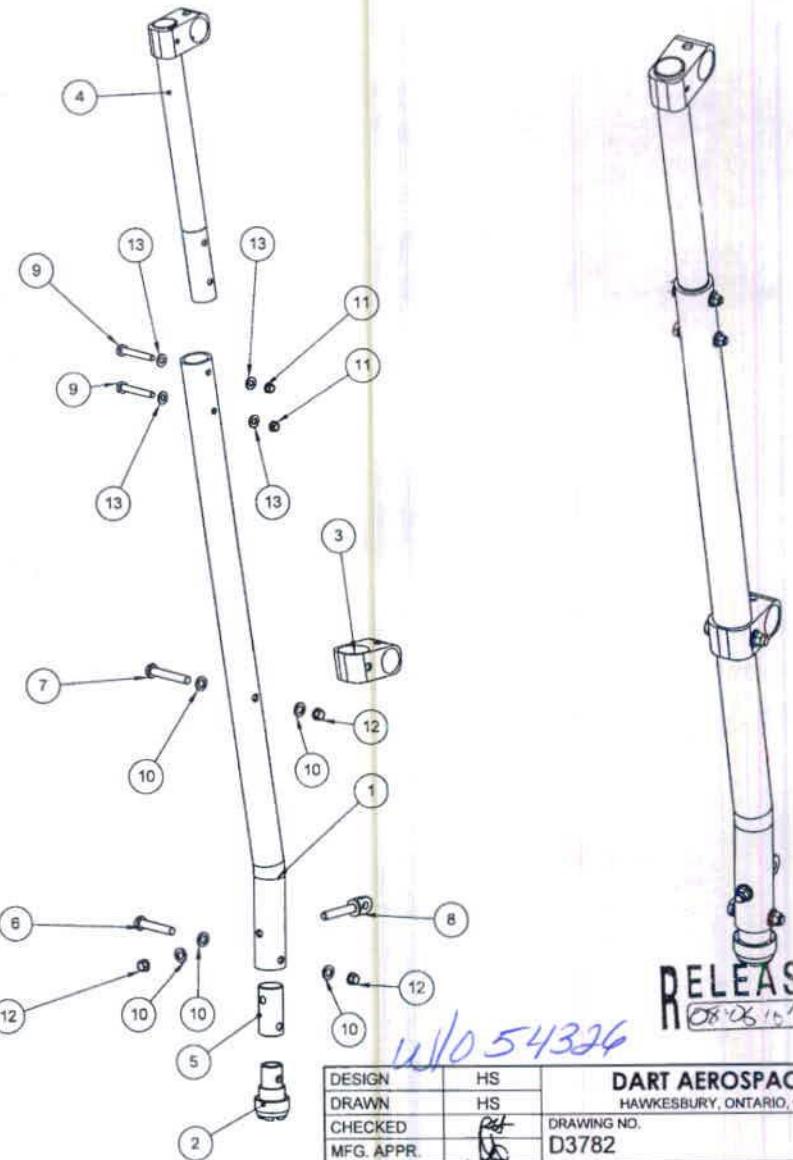
C

B



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	D3786-1	SLEEVE	1
6	AN5-15A	BOLT	1
7	AN5-17A	BOLT	1
8	AN45-15A	EYE BOLT	1
9	AN4-15A	BOLT	2
10	NAS1149D0568J	WASHER (AN960JD516)	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	NAS1149D0463J	WASHER (AN960JD416)	4

D3782-045 BACK LEG ASSY



RELEASED
08/06/11/11
WLO 54324

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3782	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LEG ASSEMBLY	NTS
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NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 4.71 lbs

